

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020040**Date Inspected:** 09-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Liu Hua Jie, Lu Li Qing, Geng W			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	Orthotropic Box Girder(OBG)		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Assembly, Bay 14, 12CE, Corner Assembly CA3005, Edge plate to Side plate.

FCAW welding of weld joint CA3005-003; located on assembly, Bay 14, 12CE. Welder is identified as 055491, 052696; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, 12AW, PP112.

FCAW welding of weld joint SEG3004D-017; located on assembly, Bay 14, 12AW. Welder is identified as 20125; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2231-TC-U4B-F.

Assembly, Bay 14, Traveler rail.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC Personnel performing Ultrasonic Testing (UT) of Traveler rail identified as 20TR2-006. The attached photographs provide additional detail.

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Assembly, Bay 14, 11EW, Deck Panel Diaphragm to Deck Panel Diaphragm.

FCAW welding of weld joint SEG073*-020; located on assembly, Bay 14, 12CE. Welder is identified as 045246; ZPMC Quality Control Inspector (QC) is identified as Liu Hua Jie. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-P-2213-B-U2-FCM-1.

Assembly, Bay 14, 12CE, Floor Beam to Bottom Panel.

FCAW welding of weld joint SEG3003G-038, 039, 042, 043; located on assembly, Bay 14, 12CE. Welder is identified as 044801; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2132.

Assembly, Bay 14, 12CE, FL2-1 flange to Longitudinal Diaphragm.

SMAW welding of weld joint SEG3003B-011, 012; located on assembly, Bay 14, 12CE. Welder is identified as 049339; ZPMC Quality Control Inspector (QC) is identified as Lu Li Qing. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2114-FCM-1.

Assembly, Bay 13, Mock-Up for 13AE.

During the Quality Assurance (QA) random in-process visual inspection, this QA inspector observed ZPMC carrying out Mock-Up for 13AE. This QA inspector noticed following things,

- fit up of Longitudinal diaphragms SA3016A/B, SA3017A/B with bottom panel in process.
- fit up of X3472D plate with bottom panel in process.

This QA Inspector carried out NDE on following

Assembly, Bay 14, 11DE, Edge Panel to Deck Panel.

This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005490), FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as SEG072*-45, 46, 47.

Assembly, Bay 14, Traveler rail.

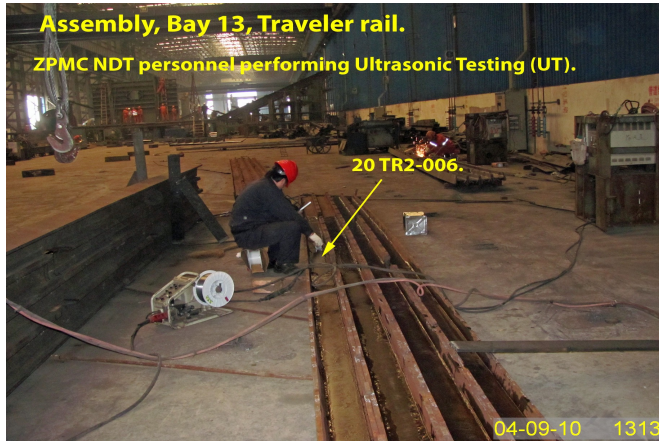
This QA inspector performs Random Ultrasonic Testing (UT) of approximately 10% area previously tested and accepted by ZPMC Quality Control personnel(Notification # 005493), FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as

- 1) 10TR3-023-007, 013.
- 2) 10TR3-022-007, 013.
- 3) 11TR2-015-007, 013.
- 4) 10TR3-034-007, 013.
- 5) 10TR3-021-007, 013.
- 6) 11TR2-014-007, 013.
- 7) 10TR3-005-007, 013.
- 8) 10TR3-031-007, 013.
- 9) 10TR3-025-007, 013.
- 10) 10TR3-032-007, 013.

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 1500.042.2372, who represents the Office of Structural Materials for your project.

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
